

Date: Thursday, 02/10/2008 8:24:12 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	VERTICAL TUNNEL W/O DUCTING	
<b>Job Number</b> :	42388			
<b>Estimate Number</b> :	13608			
<b>P.O. Number</b> :		<b>Part Number</b> :	D38285	
<b>This Issue</b> :	02/10/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D38285 PROTOTYPE	
<b>First Issue</b> :	//	<b>Project Number</b> :		
<b>Previous Run</b> :		<b>Drawing Revision</b> :	PROTOTYPE	
	<b>Type</b> :	<b>Material</b> :	KYDEX 6185 (TBD)	
	R&D THERMOFORMING	<b>Due Date</b> :	17/10/2008	<b>Qty:</b> 1 Um: Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	<u>JUL 08.10.02</u>			
<b>Comment</b> :	Est. Rev. A New Issue 08.09.25 DL			

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
1) Machine set up <span style="float: right;">DL. 08.10.03</span>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
1) Cut sheet to required blank size <span style="float: right;">DL. 08.10.03</span>		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE		
Thermoform as per Dwg. D3828-5 and folio (FTA 9226 Prototype) using tool DT 9226 <span style="float: right;">(X2)</span>		
Dwg. Rev. <u>PROTOTYPE</u> <span style="float: right;">DL. 08.10.03</span>		
Folio Rev. <u>A</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">(X2)</span>		
Visually inspect for proper formation of each part <span style="float: right;">DL. 08.10.03</span>		

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.03	4	sheet Blistered.		Scrap & Replace Reduce Heat by 4°F.	OK. 08.10.03			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL W/O DUCTING

Job Number: 42388

Part Number: D38285

Job Number:



Seq. #:	Machine Or Operation:	Description:
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

PROTOTYPE  
KEEP IN ENG'G LAB P# 09.02.20

7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



002514

fully mtl  
use 21 per Dmg

u 09.02.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries